

Work Order ID 60157

June 28, 2010 11:31:47 AM

Page 1

Item ID: D350-636-012

Revision ID:

Item Name: Skidtube RH

Start Date: 6/28/10 Start Qty: 1.00

Required Date: 7/05/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00

DC

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG 005

8/10/12/23

HJ for BG 10/07/22

B60157

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60157

June 28, 2010 11:31:52 AM



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Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)
ONLY DRILL ONE SIDE OF FWD SADDLE HOLES USING DT8150

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Clecko DT 9642 and drill fwd saddle holes on second side, ensure proper positioning.

9-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

10-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to



10-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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	PS							

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Work Order ID 60157

June 28, 2010 11:31:58 AM



Item ID: D350-636-012

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Start Date: 6/28/10 Start Qty: 1.00

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.297"

11-Open up holes of Detail A to 0.297" (total of 2 holes per side)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod batch: M114242

13-Grind welds flush as per Dwg D2750

BE 10/07/01
BE 10/07/05

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8/10/07/05

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/07/05

70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

Cust Item ID:

Customer:

6/28/10

RA

BE 10/07/07

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Item ID: D350-636-012

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 17113519
exp. date: 07/11/12

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: M114242

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

h 10/17/12

BE 10/07/12

BE 10/07/12

BE 10/07/13

BE 10/07/13

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

dwg D2750

12-Deburr holes

BE 10/07/13

0.00

0.00

8/10/07/13

0.00

0.00

8/10/07/13

(X)

170



QC

Quality Control

Memo

180



QC

Quality Control

QC10- Inspect visual per QS1004- ground welds

QC5- Inspect part completeness to step on W/O

Memo

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Item ID: D350-636-012

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Setup Start

Stop

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

=> 10/07/14

Y1 8

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

12/14/841

Memo

0.00

START TIME: 8:20

OVEN TEMPERATURE: 300°

FINISH TIME: 9:00

1 BL 10-7-19

210



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> 10/07/14

1 8

Memo

0.00

Inspect for foreign object per QSI 024

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Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



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Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



HandFinish

Hand Finishing

HandFinishing

Memo

Install inserts as per dwg D2750

0.00

=> M 10/07/21

1 0

230



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: 101A

✓ 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241
BATCH: 1115114
EXP DATE: 11101

✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: 11104189

✓ 5-Coat all exposed fasteners with "LPS Procyon"
batch: 11104251

0.00

0.00

=> M 10/07/21

1 0

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QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control



8/10/12

(40)

8/10/12 (1)

8/10/12

(40)

Work Order ID 60157

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Item ID: D350-636-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 6/28/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270



Packaging

Packaging

0.00

0.00

Packaging

Memo

Package as per PPP D350-636-012

Per H

10-7-23

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/07/26

MF 10-7-23

Picklist Print

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Page 1

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 02.09.25 Rearranged procedure steps: KJ
 IPP Rev: J 06-03-29 As per Rev D EC
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By: EC
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O
 10.06.22 revise seq110 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS4-1032-225		Purchased	No			220	Each	6,491.000	38	38			
---------------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Insert

Location

Loc Qty

Loc Code

PK011

6491

6491

10768

AN3C5A		Purchased	No			230	Each	1,232.000	34	34			
--------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Bolt

Location

Loc Qty

Loc Code

ST350

1217

114330

11

114523

18

114808

188

115015

1000

ST351

15

113121

10

114108

5

AN3C6A		Purchased	No			230	Each	501.0000	4	4			
--------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--



BOLT

Location

Loc Qty

Loc Code

ST351

501

501

11982

Y38 10/07/21

X34 10/07/21

Y4 10/07/21

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

217.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

215

111649

2

114653

38

114784

50

114941

75

115030

50

x4 10/04/21

AN8C35A

Purchased

No

230

Each

38.0000

1

1



BOLT

Location

Loc Qty

Loc Code

FP

1

110847

1

ST346

37

114442

37

x1 10/07/21

AN960C10L

NAS1149C0332
R

Purchased

No

230

Each

0.0000

38

38



washer

M115000

AN960C816L

Purchased

No

230

Each

57.0000

1

1



WASHER

x38 10/04/21

Location

Loc Qty

Loc Code

ST348

57

110584

54

111424

3

x1 10/04/21

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Page 2

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Picklist Print

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Work Order ID: 60157



Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

246.0000 8 8



Bushing

Location

Loc Qty

Loc Code

ST023

246

52311

5

57914

21

59112

220

Manufactured No

230 Each

11.0000 1 1

D3488-042



Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

11

53918

11

Manufactured No

230 Each

169.0000 8 8

D3492-041



Plug Assembly

Location

Loc Qty

Loc Code

FP013

169

58180

4

59114

80

59189

4

59420

81

x 8 11 10/07/21

x 1 11 10/07/21

x 8 11 10/07/21

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Page 3

W/O:		WORK ORDER CHANGES						
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Page 4

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Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3492-043



Plug Assembly

Manufactured No

230

Each

93.0000

8

8



Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

91

59117

7

59190

4

59421

80

xs 11 10109/21

D3535-25



Wearshoe

Manufactured No

230

Each

9.0000

1

1



Location

Loc Qty

Loc Code

FP18

9

59150

9

xl 11 10107/21

D3536-25



Gasket

Manufactured No

230

Each

39.0000

1

1



Location

Loc Qty

Loc Code

FP12

39

58820

15

59625

24

xl 11 10102/21

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W/O:		WORK ORDER CHANGES					
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Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Manufactured No

230

Each

50.0000

3

3



Wearpad

Location

Loc Qty

Loc Code

FP

1

B 59593

X3

10/07/21

55465

1

FP17

25

57713

3

59116

22

FP18

24

59710

24

D3631-1

Manufactured No

230

Each

351.0000

8

8



Washer

Location

Loc Qty

Loc Code

ST076

351

52693

206

54388

145

X4

10/07/21

D3672-1

Manufactured No

230

Each

1,159.000

4

4



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

1159

51674

159

52505

1000

X4

10/07/21

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Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No 230 Each 18.0000 1 1



Wearplate

Location

Loc Qty

Loc Code

FP17

18

B59626

58573

11

58906

7

D3793-1 Manufactured No 230 Each 12.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP18

12

59151

12

D3793-3 Manufactured No 230 Each 11.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP18

10

59152

10

FP19

1

57947

1

D3794-1 Manufactured No 230 Each 29.0000 1 1



Gasket

Location

Loc Qty

Loc Code

FP010

29

57942

18

59627

11

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:31:33 AM

Page 7

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

22.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP18

22

56066

11

59153

11

MS21043-6

Purchased No

230

Each

766.0000

4

4



NUT

Location

Loc Qty

Loc Code

ST301

766

12314

766

MS21083C8

Purchased No

230

Each

93.0000

1

1



NUT

Location

Loc Qty

Loc Code

ST303

93

113845

7

14934

86

NAS1611-010

Purchased No

230

Each

275.0000

8

8



O-RING

* PTO =>

Location

Loc Qty

Loc Code

FP

275

110715

100

110915

175

X1 10/07/21

X4 10/07/21

X1 10/07/21

PTO =>

June 28, 2010 11:31:33 AM

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Page 7

W/O: 60157		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/21	230	Replacc NAS 1611-010 "O" Rings with Q2594-3 / B59358 "O" Rings	M	10/07/21	18		S 10/07/21

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:31:34 AM

Page 8

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

139.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

139

114451

101

114496

38

Purchased

No

250

Each

79.0000

2

2

AN8C21A



BOLT

Location

Loc Qty

Loc Code

ST345

79

113558

39

114653

40

Purchased

No

250

Each

57.0000

1

2

AN960C816L



WASHER

Location

Loc Qty

Loc Code

ST348

57

110584

54

111424

3

Manufactured

No

250

Each

32.0000

1

1

D2741



Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST466

32

55905

12

57949

20

X8 10/07/21
2 ~

11 3558

11 0589

55905

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Page 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:31:41 AM

Page 9

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

45.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST065

45

57825

3

59127

42



59127

2

59426

Le

D3532-1

Manufactured No

250

Each

5.0000

2

2



Spacer

Location

Loc Qty

Loc Code

ST068

5

52321

5



59426

2

Le

D3672-13

Purchased No

250

Each

864.0000

2

2



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

864

54363

864



54363

2

Le

MS21083C8

Purchased No

250

Each

93.0000

1

2



NUT

Location

Loc Qty

Loc Code

ST303

93

113845

7

114934

86



114934

1

Le 1/4/22 ①

D2600-3-BENT

Manufactured No

110

Each

0.0000

1

1



Extrusion Bent

A

B59410

①



DP

10-6-29

June 28, 2010 11:31:41 AM

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Page 9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:31:41 AM

Page 10

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 110 Each 42.0000 1 1
Cap

Location	Loc Qty
LG	42
51922	6
59198	36

Loc Code



1

BE 10/07/01

D2739 Manufactured No 160 Each 2.0000 1 1
350 I Beam

Location	Loc Qty
LG	2
59406	2

Loc Code



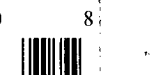
D60225

D 11/07/17

D2743 Manufactured No 160 Each 331.0000 8 8
Crossbolt Spacer

Location	Loc Qty
LG	331
50281	10
57953	2
59111	319

Loc Code



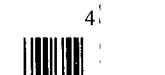
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BE 10/07/08

D3490-3 Manufactured No 160 Each 22.0000 4 4
Cross Bolt Spacer

Location	Loc Qty
LG	22
59229	22

Loc Code



4

BE 10/07/08

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Page 10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 11:31:47 AM

Work Order ID: 60157

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Page 11

Start Date: 6/28/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

35.0000

4

4



Cross Bolt Spacer



Location

Loc Qty

Loc Code

LG

35

59424

35

4 BE 10/07/08

June 28, 2010 11:31:47 AM

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-8	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

who
bol57

RELEASED
68-07-22-14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS. CHANGE INSERTS: ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F

SHEET 1 OF 11

TITLE

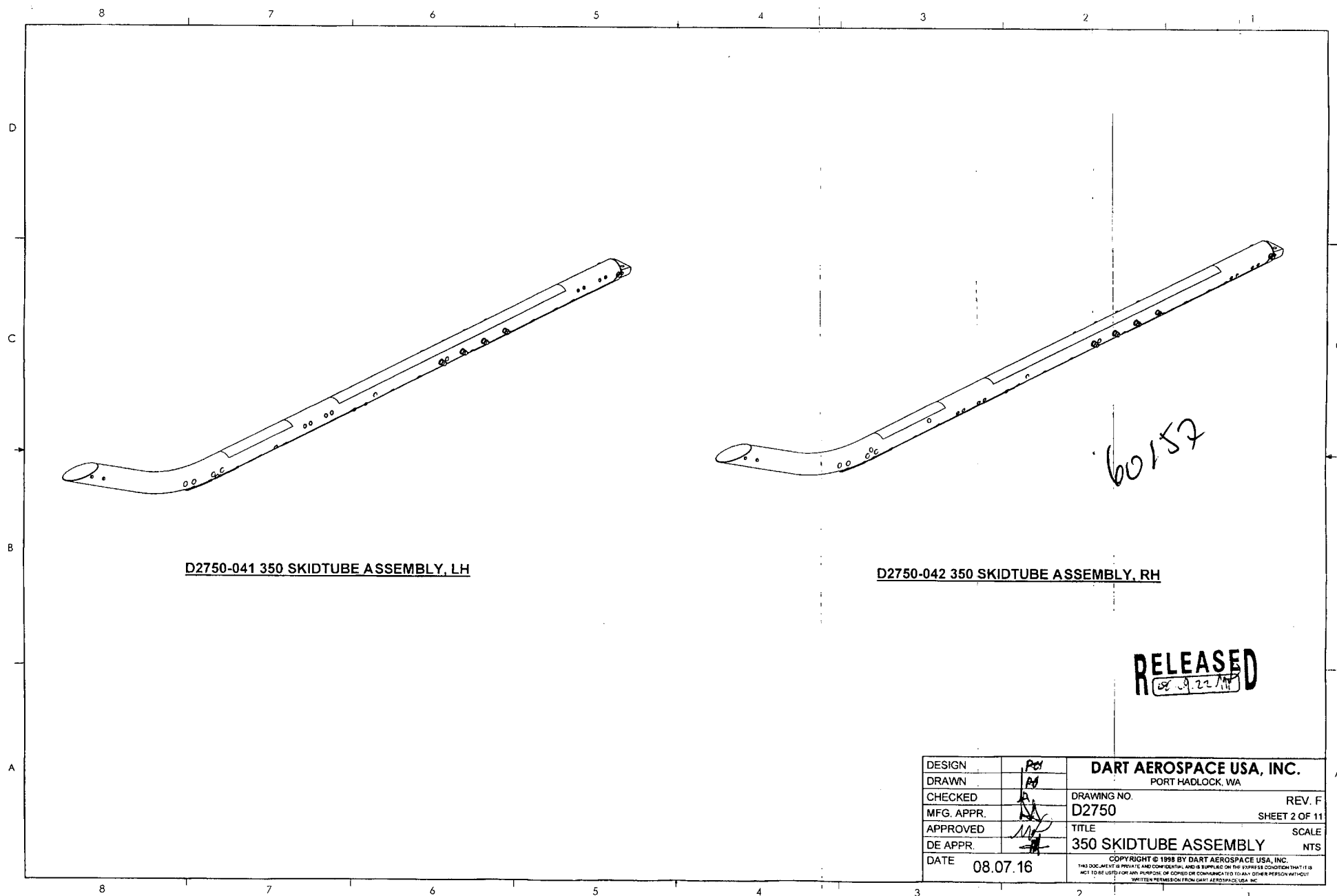
350 SKIDTUBE ASSEMBLY

SCALE

NTS

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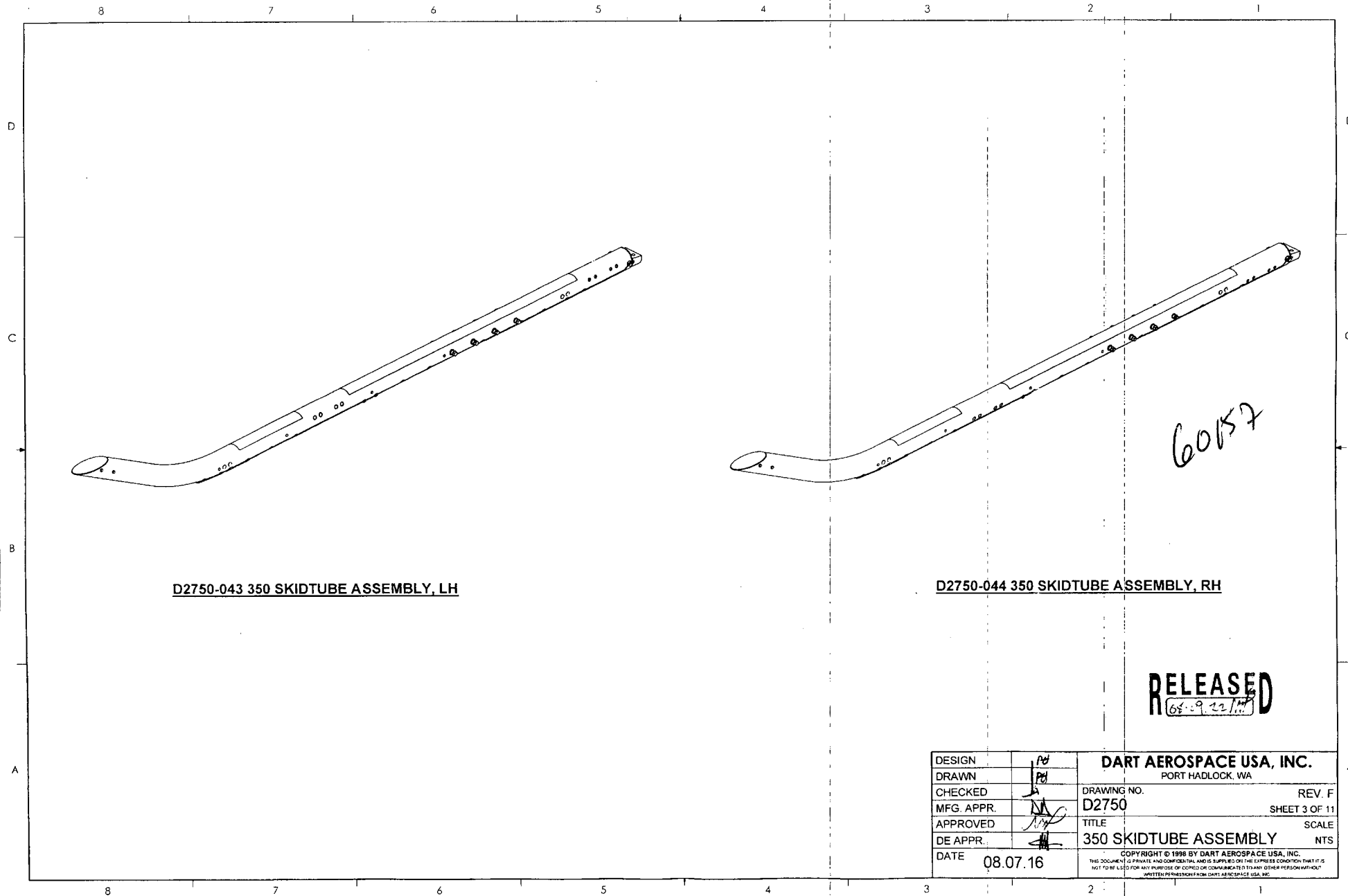


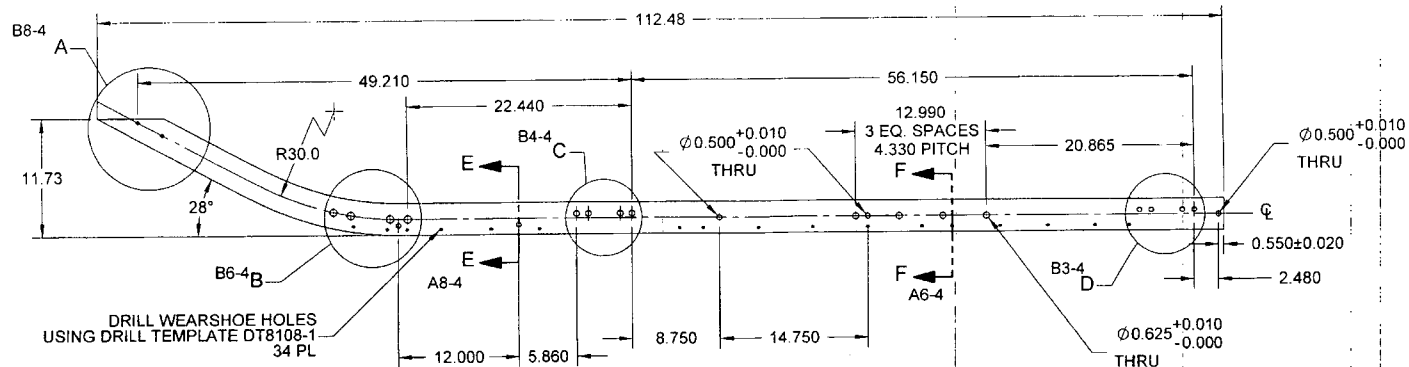
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D2750-042 350 SKIDTUBE ASSEMBLY, RH

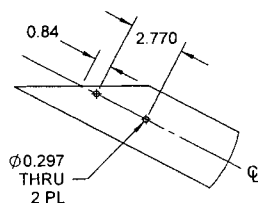
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89.9.22/11

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CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY NTS	
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

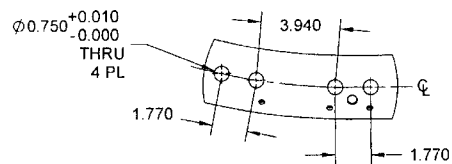




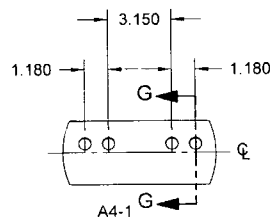
D2750-1 LH SKIDTUBE



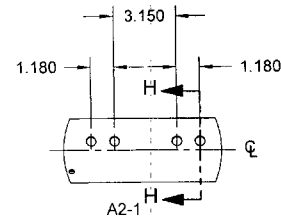
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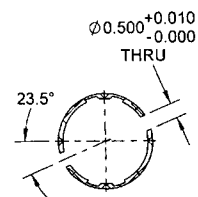
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SCALE 2X



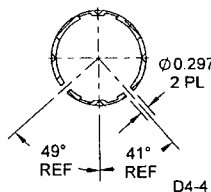
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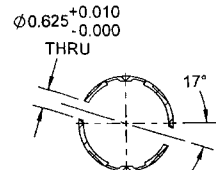
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SCALE 2X



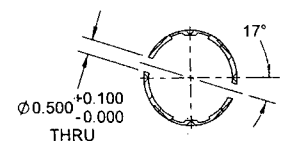
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

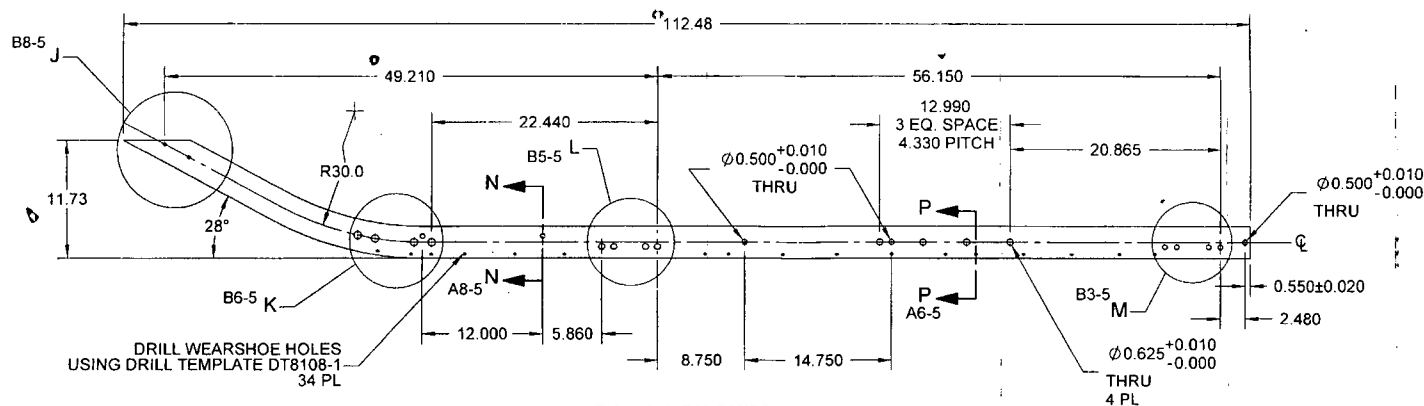


SECTION H-H
SCALE 3X, 4 PL

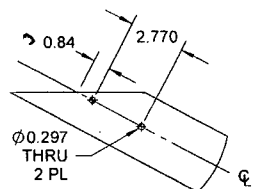
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DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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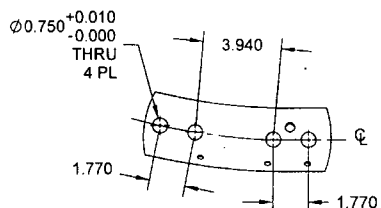
60157



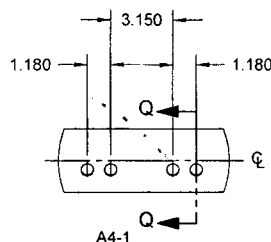
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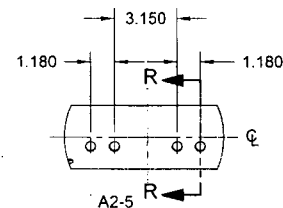
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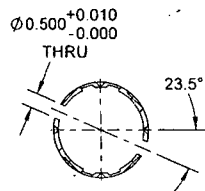
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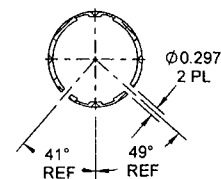
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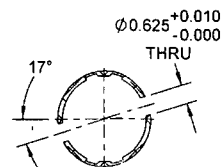
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SCALE 2X



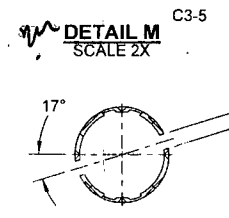
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

W/O 60157

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DRAWN	PC	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
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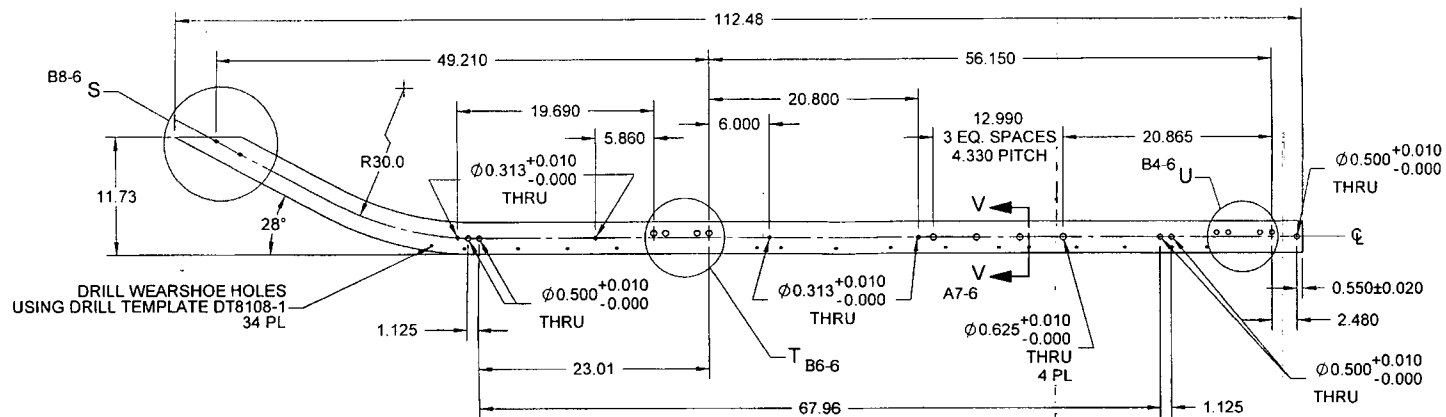
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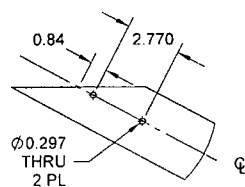
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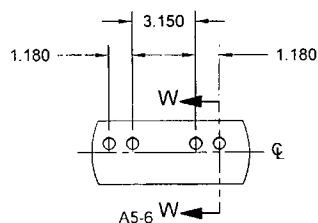
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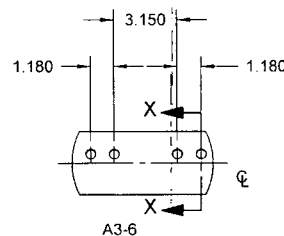
D2750-3 LH SKIDTUBE



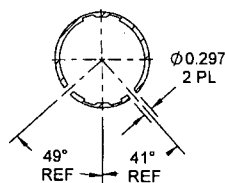
DETAIL S
SCALE 2X



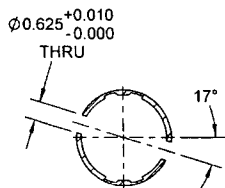
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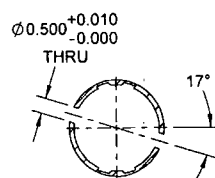
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL









SECTION W-W
SCALE 3X, 4 PL

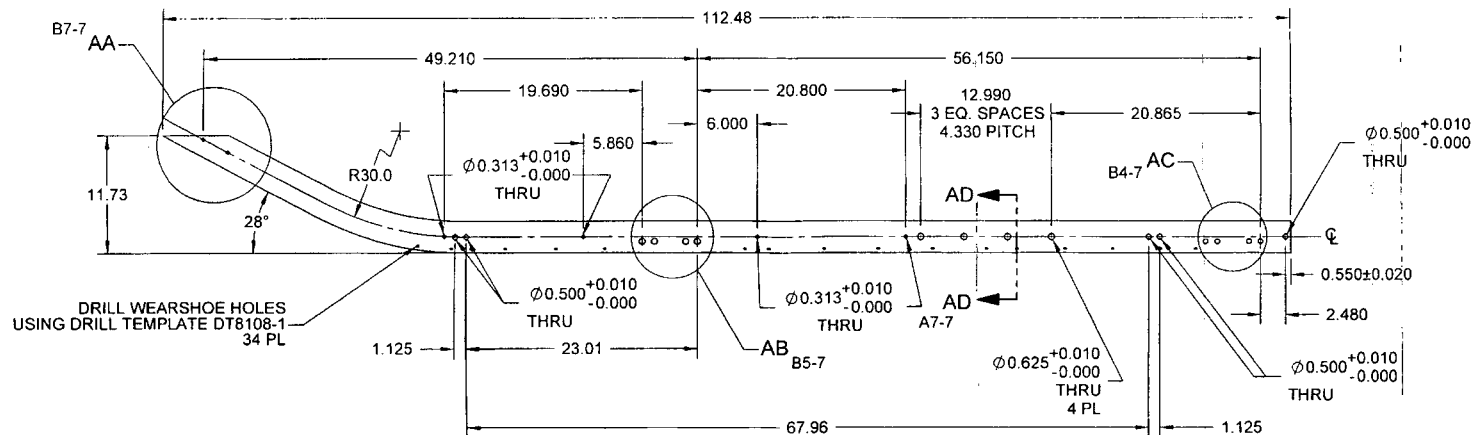


SECTION X-X
SCALE 3X, 4 PL

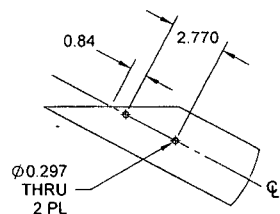
60057

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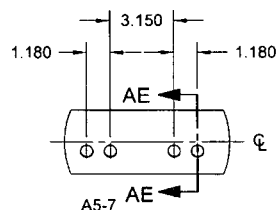
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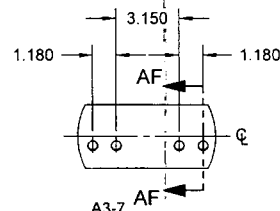
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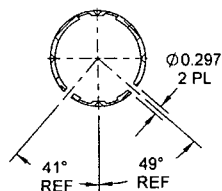
DETAIL AA
SCALE 2X
D7-7



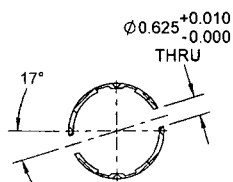
DETAIL AB
SCALE 2X
C4-7
A5-7



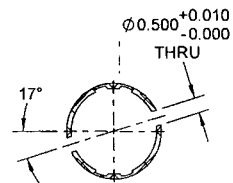
DETAIL AC
SCALE 2X
D3-7
A3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7

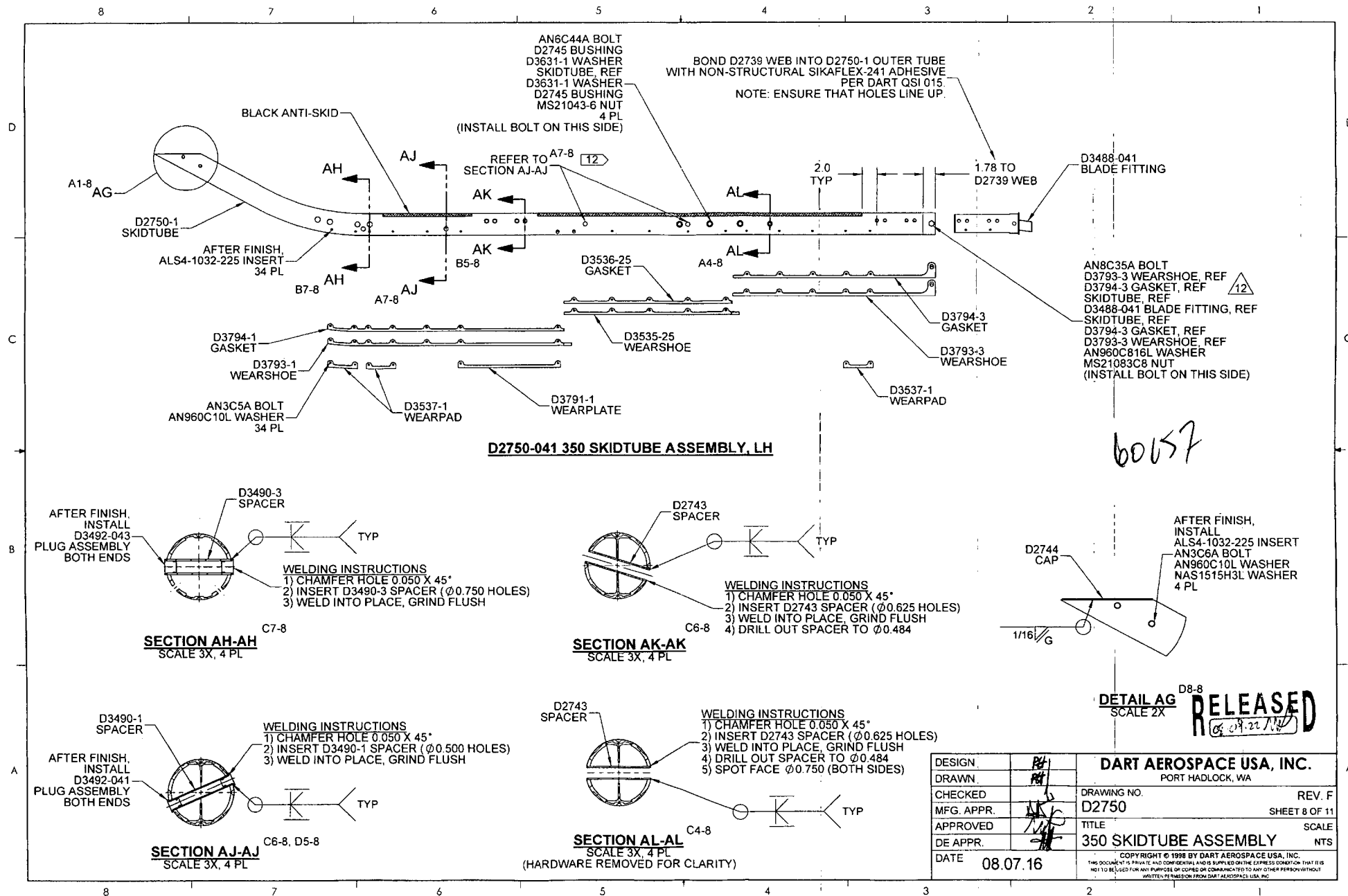


SECTION AF-AF
SCALE 3X, 4 PL
B4-7

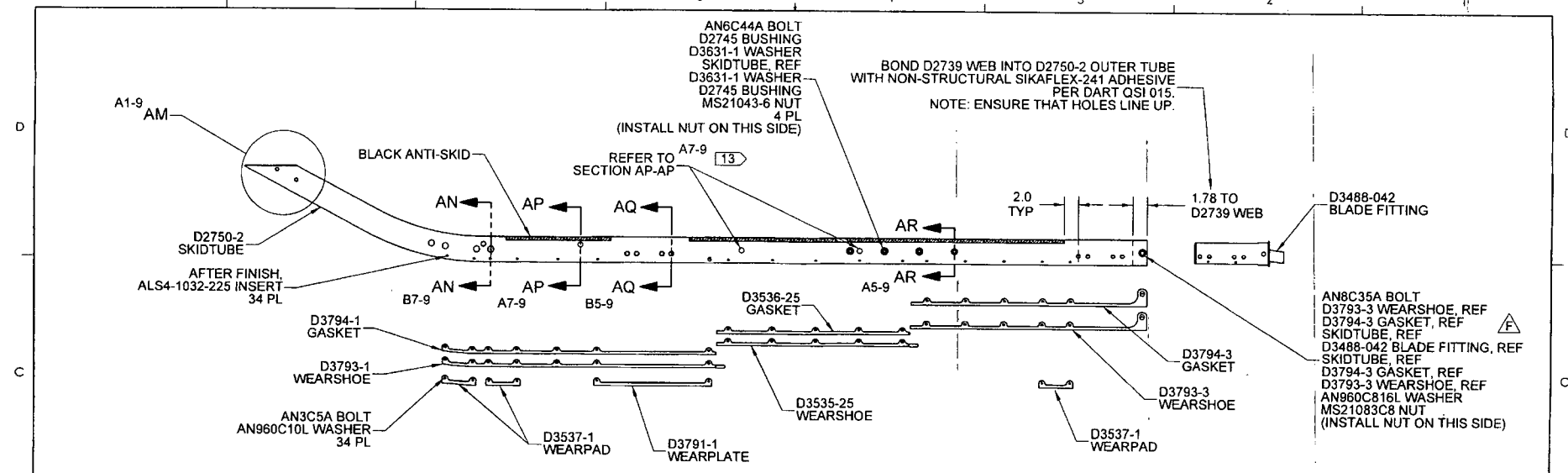
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08-09-2010

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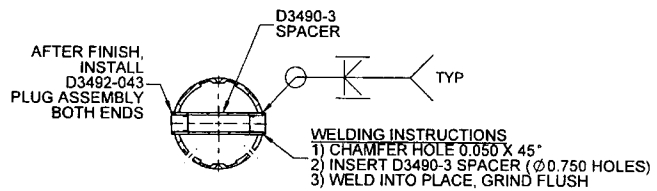


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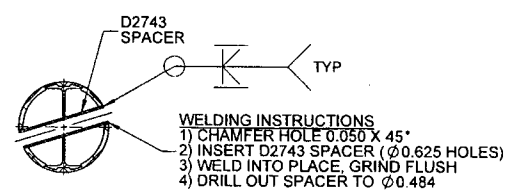


D2750-042 350 SKIDTUBE ASSEMBLY, RH

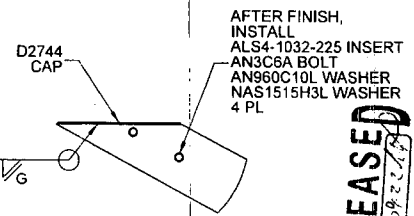
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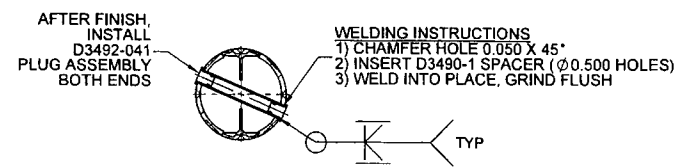
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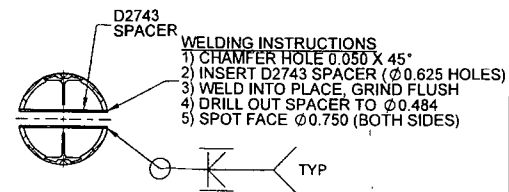
SECTION AQ-AQ
SCALE 3X, 4 PL



DETAIL AM
SCALE 2X



SECTION AP-AP
SCALE 3X, 4 PL

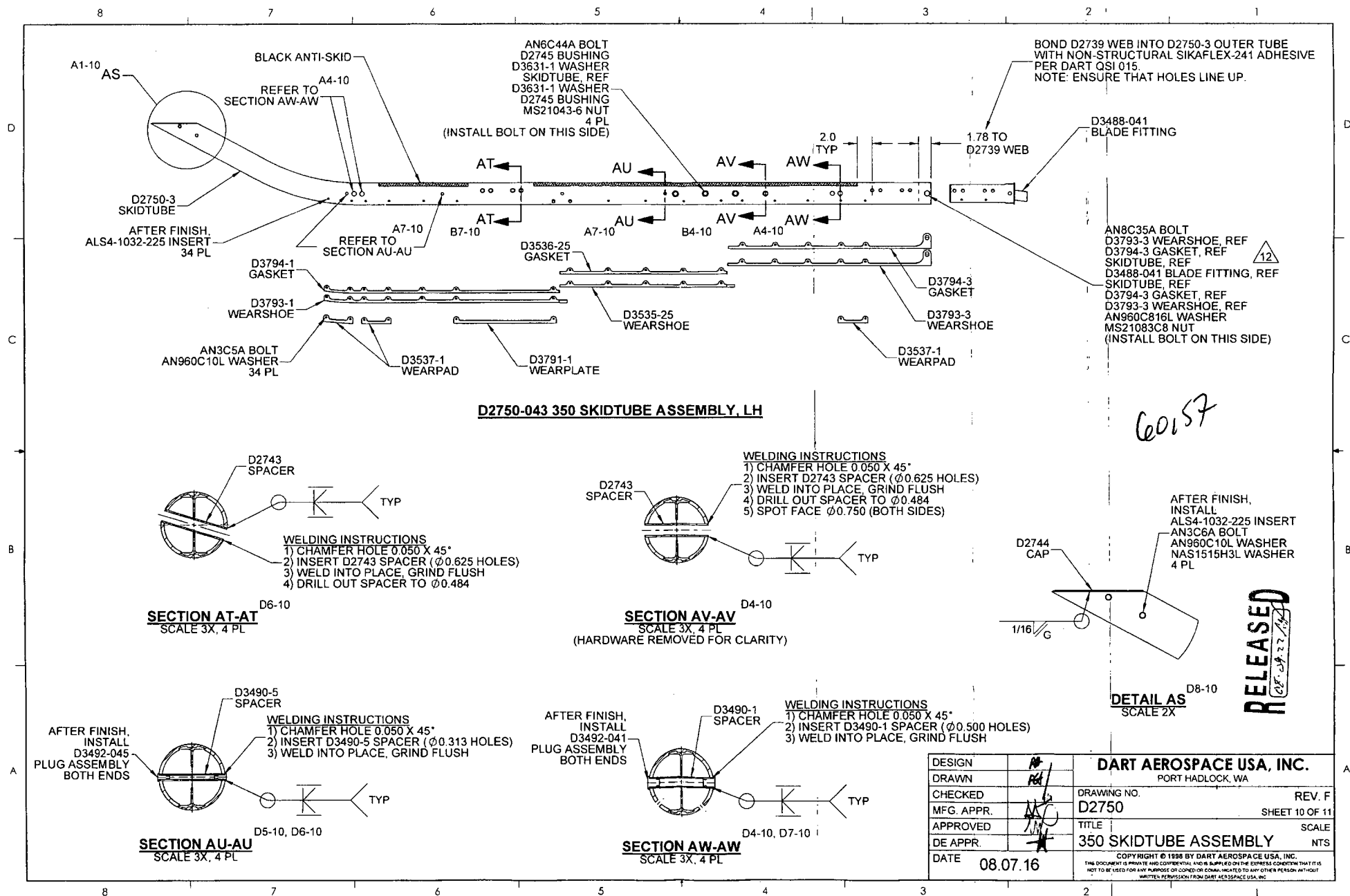


SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

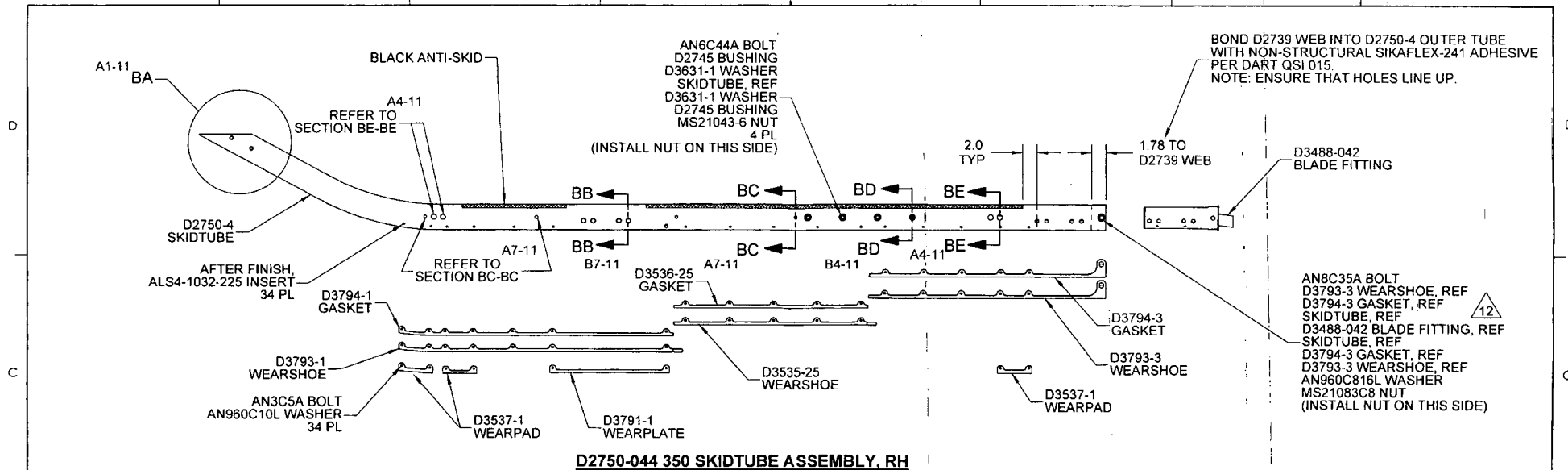
DESIGN	PH	DART AEROSPACE USA, INC.	
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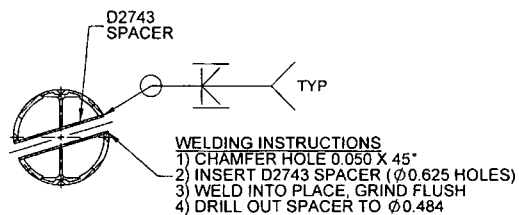
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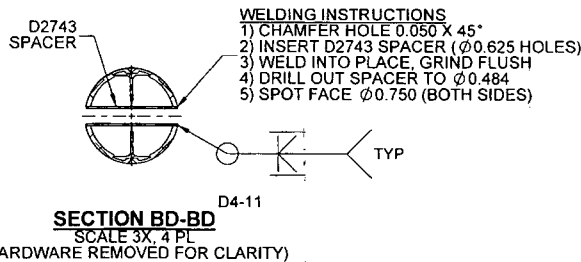
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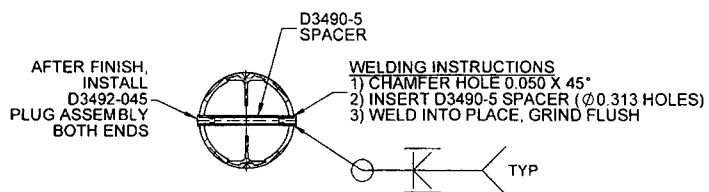
D2750-044 350 SKIDTUBE ASSEMBLY, RH



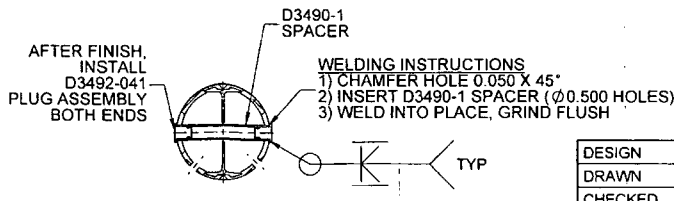
SECTION BB-BB
SCALE 3X, 4 PL



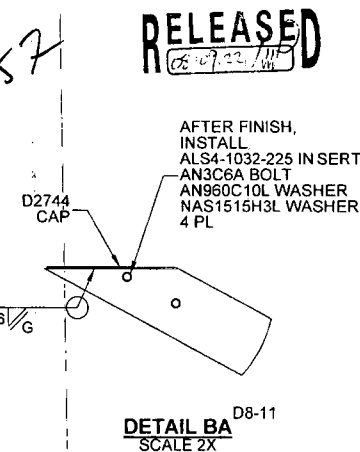
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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60157

NO. 234

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 59818
Part number: D350-626-011
Description: 350 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pch D.A. Date of Test Coupon 10-06-21
Welder Barclay Elliott Date of Test Coupon 10-06-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld